

Date: Friday, 05/09/2008 10:10:08 AM  
User: Julie Lecocq

## Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services	Drawing Name	: SQUARE SLEEVE
Job Number	: 41866		
Estimate Number	: 13470		
P.O. Number	:	Part Number	: PB6743001121
This Issue	: 05/09/2008 S.O. No. :	Drawing Number	: B6743001 PAGE34
Prsht Rev.	: NC	Project Number	: N/A
First Issue	: / / Type : MACHINED PARTS	Drawing Revision	: B1
Previous Run	: 40612	Material	:
Written By	:	Due Date	: 26/09/2008
Checked & Approved By	: <u>JLD 08.9.05</u>	Qty:	10 Um: Each
Comment	: Est Rev:A 08-07-17 new issue DD verified by:EC		

## Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	M6061T6B1250X01250	6061-T6 Bar 1.25 x 1.25
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Comment: Qty.: 0.4112 f(s)/Unit Total: 3.2894 f(s)  
6061T6 bar 1.25 x 1.25  
batch: M109058

J.L 08/09/12

2.0	BAND SAW	BAND SAW
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Comment: Cut blank 4.8" long

J.L 08/09/12

3.0	HAAS1	HAAS CNC VERTICAL MACHINING #1
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Comment: 1- Machine as per Folio FA567 and Dwg PB67-43001  
2- deburr

J.LP 08/09/14

(10)

4.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
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Comment: INSPECT PARTS AS THEY COME OFF MACHINE

J.LP 08/09/14

(10)

5.0	QC8	SECOND CHECK
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Comment: SECOND CHECK

J.LP 08/09/14

(10)

6.0	HAND FINISHING1	HAND FINISHING RESOURCE #1
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Comment: HAND FINISHING RESOURCE #1  
Chemical Conversion Coat as per QSI 005 4.1

M.L 08/09/16

08/09/16

(10X)

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

Date: Friday, 05/09/2008 10:10:08 AM  
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## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: SQUARE SLEEVE

Job Number: 41866

Part Number: PB6743001121

Job Number:



Seq. #:

Machine Or Operation:

Description :

7.0

POWDER COATING

POWDER COATING



M102316



Comment: POWDER COATING

1- mask inside of tube before powder coating

2- Powder Coat Green Sandtex (Ref: 4.3.5.8) as per QSI 005 4.3

START TIME: 2:10pm

OVEN TEMPERATURE: 320°F

FINISH TIME: 2:40pm

MF

08-09-16

GO

8.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



10X

Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

MF

08/09/17

9.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: ST 128

SS

08/09/17

X

10.0

QC21

FINAL INSPECTION/W/O RELEASE



08/09/18

Comment: FINAL INSPECTION/W/O RELEASE

Job Completion



MF 08-09-18

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	

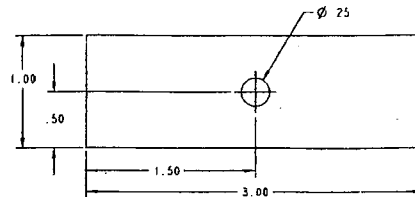
Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

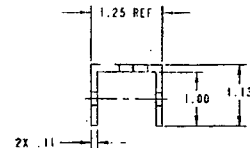
NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

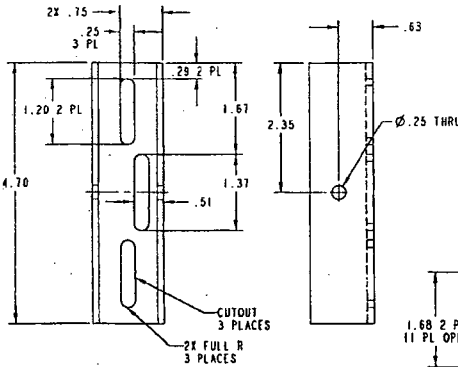
RELEASED  
# 06-01-20



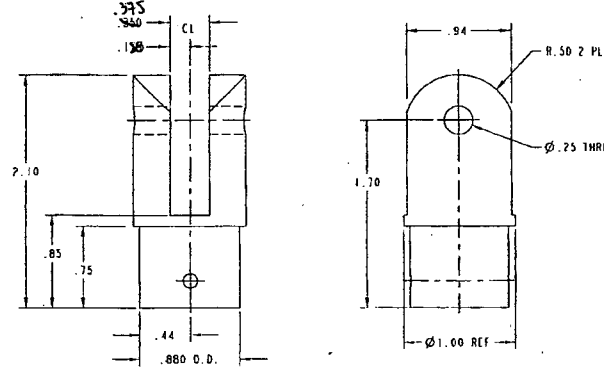
① -271 DOUBLER  
MATE: .125 THK, 6061-T6, QQ-A-250/11  
SCALE 2.000



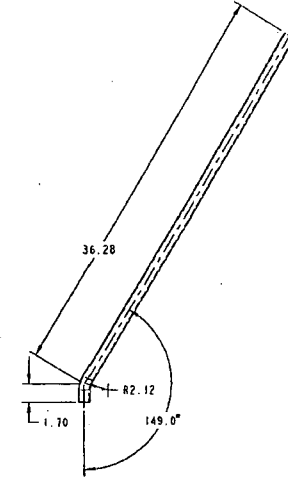
① -125 CLEVIS  
MATE: 1.00 RND, 6061-T6, QQ-A-200/8  
SCALE 2.000



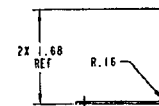
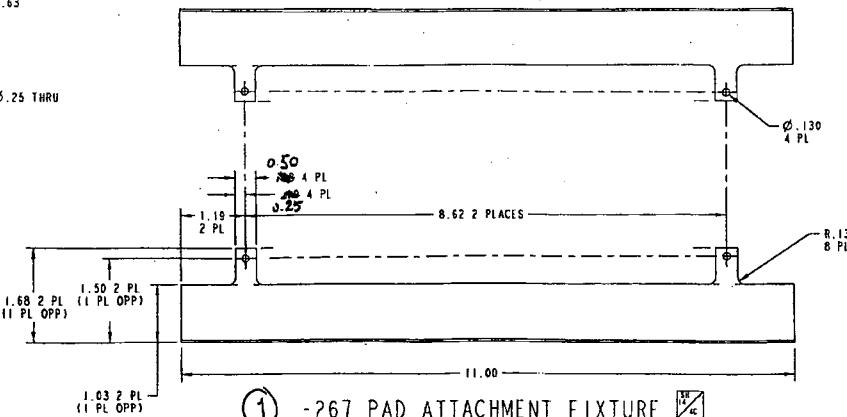
① -121 SQUARE SLEEVE  
MATE: 1.25 SQ, 7075-T6, QQ-A-200/11  
SCALE 1.000



① -267 PAD ATTACHMENT FIXTURE  
MATE: .032 THK 2024-T3, QQ-A-250/4  
SCALE 1.000



① -343 TUBE ARM  
MATE: 1.00 O/D X .065 WALL 6061-T6 TUBE  
NW-T-700/6  
SCALE 0.200



PREMIER AVIATION, INC.  
5001 Aviation Parkway, Grand Prairie, Texas 75052  
D/SUV8 B67-43001  
SCALE: 1:1 SHEET 34 OF 45

ORIGINAL

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